

Date: Thursday, 01/05/2008 11:56:56 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM		
Job Number	: 38943						
Estimate Number	: 12973						
P.O. Number	:			Part Number	: D36461		
This Issue	: 01/05/2008 S.O. No. :			Drawing Number	: D3646 REV.A		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / / Type : SMALL /MED FAB			Drawing Revision	: A		
Previous Run	: 37098			Material	:		
Written By	:			Due Date	: 06/05/2008 Qty: 10 Um: Each		
Checked & Approved By	: JUD 08-5-01						
Comment	: Est Rev. A new issue 07.07.25 EC verified by:JLM						
Additional Product							
Job Number:							
Seq. #:	Machine Or Operation:	Description :					
1.0	M304TR0500W035	304 RD Tube .500 x .035W					
							
Comment: Qty.: 2.0790 f(s)/Unit Total: 20.7900 f(s) Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)							
Batch: M107 403 (17) M107 166 (33) 8B 08/05/02							
2.0	BRAKE NC	NC BRAKE					
							
Comment: NC BRAKE							
1-Punch to length as per Dwg D3646 & template DT8958 5P 08/05/02							
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1					
							
Comment: SMALL & MEDIUM FAB RESOURCE 1							
1-Deburr CB 08/05/05 (20)							
4.0	QC5	INSPECT WORK TO CURRENT STEP					
							
Comment: INSPECT WORK TO CURRENT STEP S 08/05/05 (20)							
5.0	POWDER COATING	POWDER COATING					
							
Comment: POWDER COATING M100 700							
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3							
START TIME: 10:45AM 91 08-05-05 (20)							
OVEN TEMPERATURE: 320°F							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 11:56:56 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 38943

Part Number: D36461

Job Number:



Seq. #: Machine Or Operation:

FINISH TIME:

11:15AM

Description :

SL 08-05-05

XD

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



QX

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/L 08/05/06

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

LSD (20)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/08 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M/L 08-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

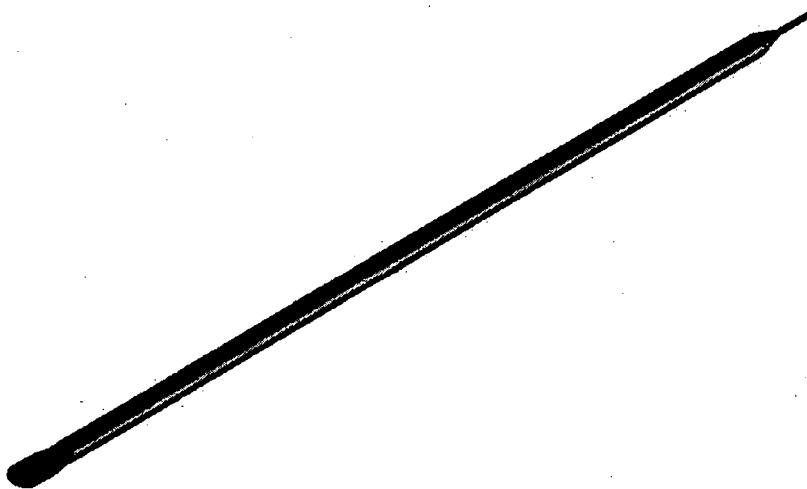
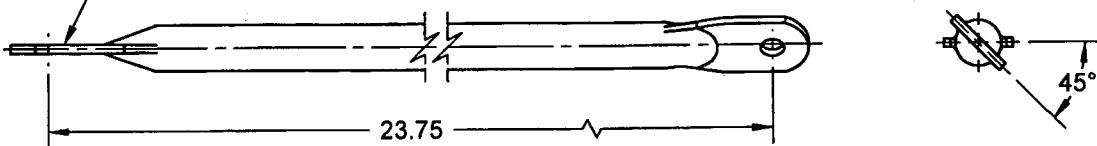
NOTE: Date & initial all entries

DART

DESIGN <i>BS</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D3646	REV. A SHEET 1 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:2
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE	

RELEASED07.07.11 *JH*

PUNCH BOTH ENDS PER
DART SPEC CONTROL
DRAWING D2727



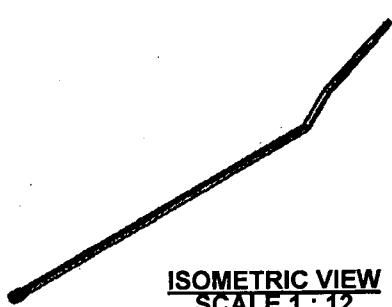
SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 38943

D3646-1 ARM**NOTES:**

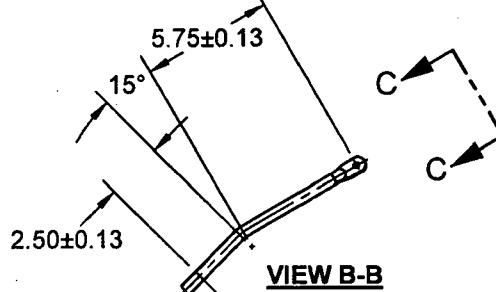
- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D3646	REV. A SHEET 2 OF 2
DATE 07.06.06	TITLE ARM	SCALE 1:8	

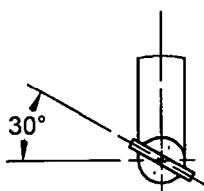
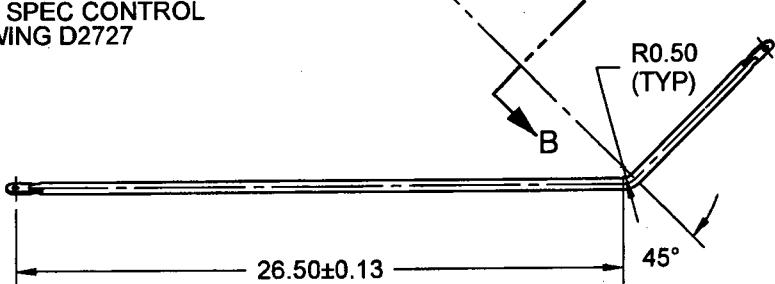


ISOMETRIC VIEW
SCALE 1 : 12



VIEW B-B

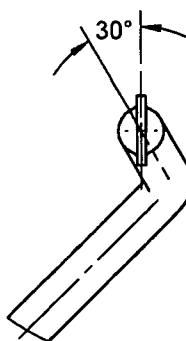
PUNCH BOTH ENDS PER
DART SPEC CONTROL
DRAWING D2727



DETAIL A
SCALE 1 : 2

RELEASED

07-07-06



VIEW C-C
SCALE 1 : 2

D3646-3 ARM

NOTES:

- 1) MAKE PER TEMPLATE DT8959
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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WORK ORDER
NO. 38943

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